

Work Order ID 67516

Saturday, March 26, 2011 9:16:15 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *ME*Date: *11-03-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100



Large Fab

Weld per dwg A/R S.S. rod Batch: *115928* 0.00
Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds 0.00

Memo

0.00

*QPL 11-04-04**FE 11-04-04*

1

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Sulot/04



125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

1 BL 11-4-4.

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

M 115 951.

1ST COAT:

START TIME: 2:40

OVEN TEMPERATURE: 400°

FINISH TIME: 3:10

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 BR 11-4-4.

140



HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M116402 / M116123

1 d 11/10/05

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

S

0.00

S 1164605

1

Quality Control

160

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

B 67514

0.00

S 1164605

1

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/10

MF
11-04-05

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Picklist Print

Saturday, March 26, 2011 9:16:11 AM

Page 1

Work Order ID: 67516

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041□KJ/RF
IPP Rev:N□06.04.05 Added level21 EC
IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
VERIFIED BY:DD
IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
by:EC IPP Rev:R 10.06.29
added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 Clevis		Manufactured	No			100	Each	24.0000	2	2			
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				WA005				24					
				55729				24					
*** ONLY APPLICABLE ON D130-701-041 -IF NOT USED, PLEASE MARK N/A ***													
D2232-1 Basket Hinge		Manufactured	No			100	Each	6.0000	2	2			
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				WA005				6					
				55791				6					
D2327-1 Spacer Bushing		Manufactured	No			100	Each	25.0000	2	2			
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				WA005				25					
				60174				5					
				64899				20					

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Page 2

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100

Each

4.0000

1

1



Label Plate



Cpl 11-04-04

Location

Loc Qty

Loc Code

WA006

4

65279

1

65539

3

①

D2581

Manufactured No

100

Each

38.0000

2

2



Mounting Bracket



Cpl 11-04-04

Location

Loc Qty

Loc Code

WA005

38

66500

14

66806

24

②

D3166-3

Manufactured No

100

Each

7.0000

1

1



Basket Hoop



Cpl 11-04-04

Location

Loc Qty

Loc Code

WA007

7.000021053

55697

2.1053E-05

64244

1

64928

6

③

M304EX0.75-16F

Purchased No

100

sf

470.0000

18

18.94737



Expanded Metal Flat SS



SAD 11-03-30

Location

Loc Qty

Loc Code

WA

470.000043

114809

0.000043

115012

150

117197

320

18.94737

Saturday, March 26, 2011 9:16:12 AM

Shop Packet Print

Page 2

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Page 3

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Parent Item Name: Basket Lid 205/350



Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

1,099.377

43.5804

45.87411



304 SQ Tube .75x.75x.065W



Cpl 11-03-30

Location

Loc Qty

Loc Code

WA007

1099.377169

116267

200.4298

116763 •

898.947369

45.87411

Saturday, March 26, 2011 9:16:12 AM

Shop Packet Print

Page 3

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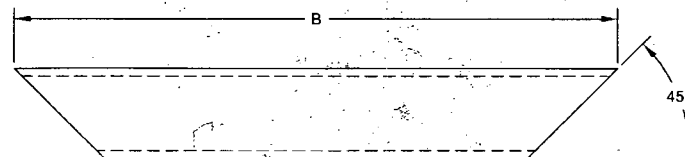
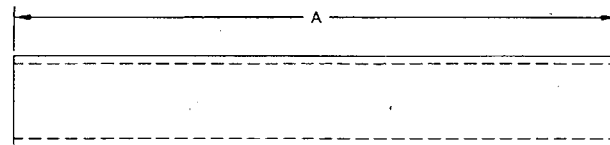
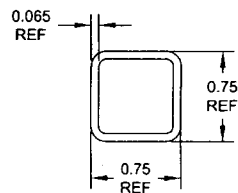
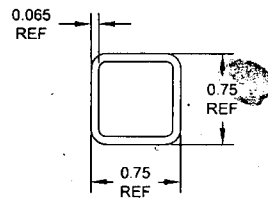
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

67516

RELEASED

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

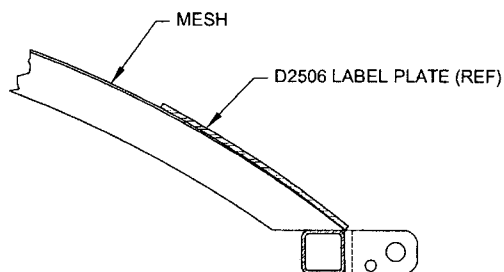
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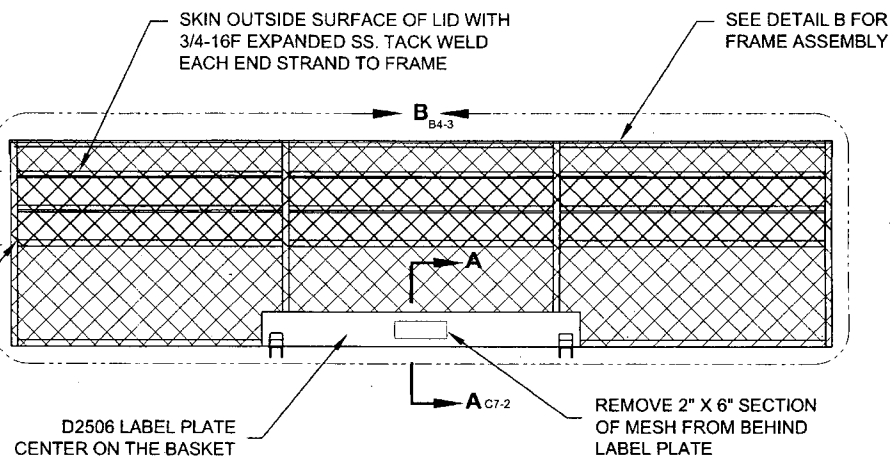
NOTE: Date & initial all entries



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

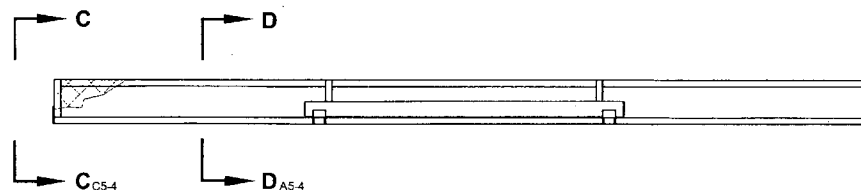


#6756



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004



RELEASED
05-05-21/11

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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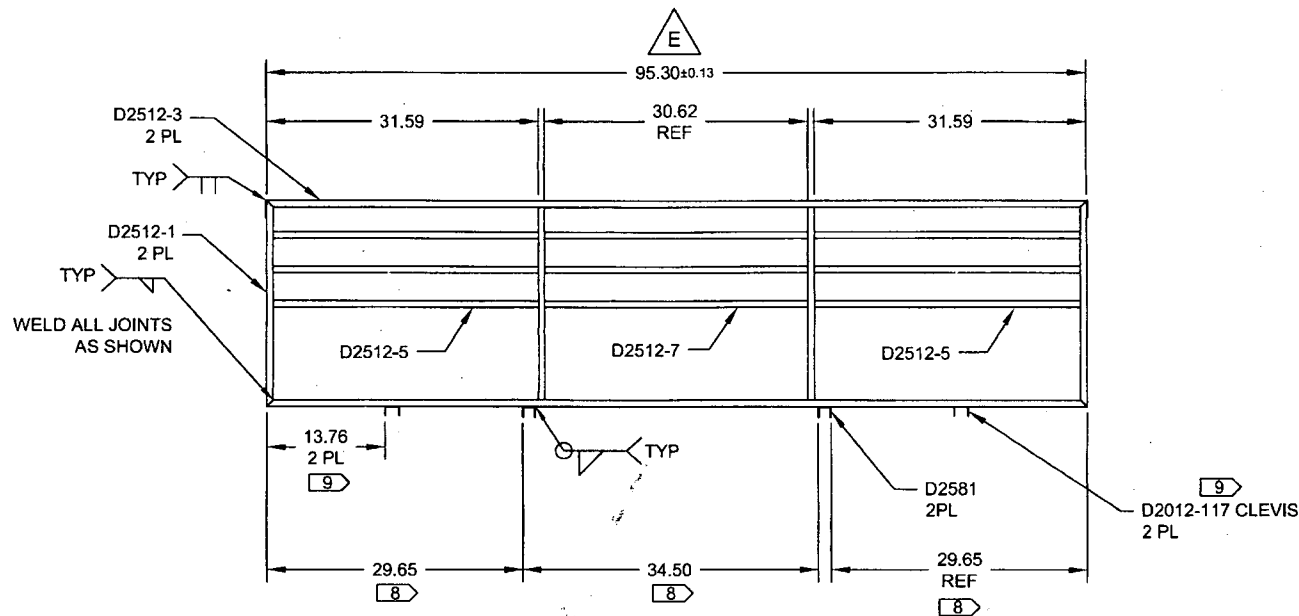
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

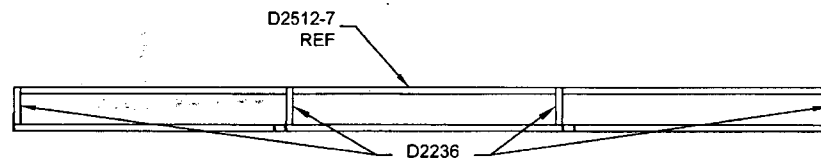
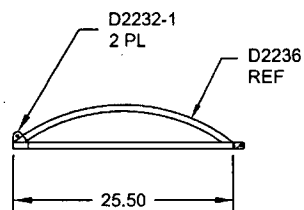
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	N	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	HA	BASKET LID ASSEMBLY (350/212)	NTS
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RELEASED
08 06 17 17

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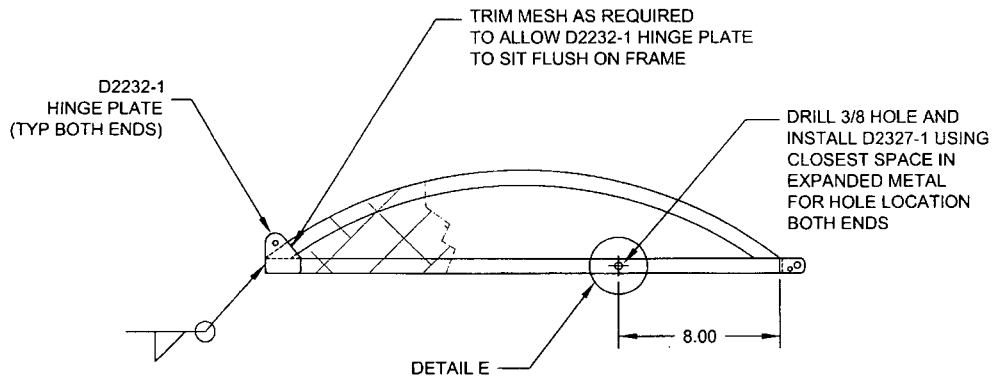
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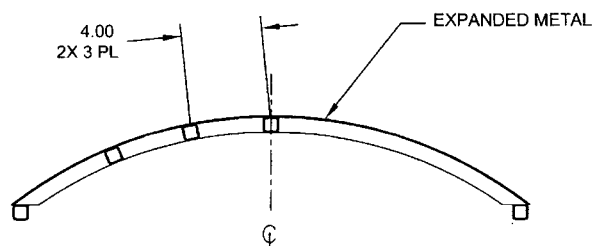
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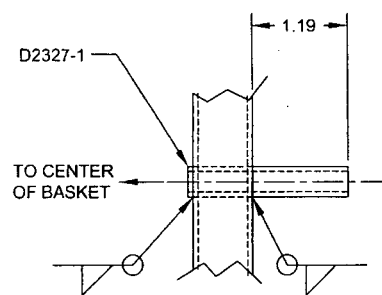
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

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